

Work Order ID 140016***140016***

Page 1

Thursday, December 17, 2015 8:13:58 AM

Item ID: D3801-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hand Retractable Spring Plunger

Start Date: 12/17/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/17/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLS Date: DEC 17 2015

Tooling:

Date:

Run Start ***NR1***QC: 97

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3801	B
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100	PURCHASING	0.00
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100

Purchasing

Memo

0.00

Purchasing

Issue P/O: 30763

Purchase Part Number: KBP-504

Supplier: Essentra

Certificate of conformity is required

CY DEC 17 2015

110	Receive & Inspect for Damage & Mat'l Certs	0.00
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110

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

6X SP15-12-21

120	QC6- Inspect dimensions to drawing	0.00
-----	------------------------------------	------

120

QC

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D3801

⑥ 16-01-08

DAS
9
9-89**P.T.O.**

DQA:

Date: 16/02/02



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 16/02/02

Work Order update only ☐

Work Order: <u>140016</u> Part No. <u>D3801-1</u> NCR No. <u>16-5560</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☒					
Date: <u>16-01-03</u>		Step #: <u>120</u>		QTY Effective: <u>6</u>			MRB (QSI04) Approval DAS 22 9-89 16-01-03 Completed By JAN 08 2016 DAS 28 Lead hand/Supervisor Approval Verification DAS 9 9-89 16-01-03 QC / QA Coordinator Approval DAS 9 9-89 16-01-03		
Description Work Order Deviation				Disposition					
Dimension "F" is 1.50", should be 1.71" Shape of knob was is different from drawing.				Acceptable					
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☒ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ ☒ Fit Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐							
OTHER: ☐									

Work Order ID 140016

140016

Page 2

Thursday, December 17, 2015 8:13:58 AM

Item ID: D3801-1

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N900040100

Setup Start *NS1*

Revision ID:

Item Name: Hand Retractable Spring Plunger

Stop *NS2*

Start Date: 12/17/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/17/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>ST034</i>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.01							
Quality Control									

JAN 11 2016

D4S
6
889

JAN 11 2016

JAN 11 2016

JAN 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
		OTHER : ☐							

Picklist Print

Thursday, December 17, 2015 8:14:03 AM

Page 1

Work Order ID: 140016

140016

Parent Item: D3801-1

D3801-1

Parent Item Name: Hand Retractable Spring Plunger

Start Date: 12/17/2015

Required Date: 12/17/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-07-22 new issue DD verified by:EC
12.03.06 AS PER DWG REV.B DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
KBP-504		Purchased	No			110	Each	0.0000	1	6			

KRP-504

Hand Retractable Spring Plunger

**

6x SP15-12-21

DQA: _____ Date: _____



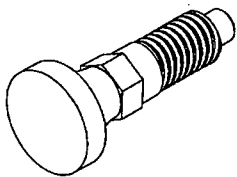
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

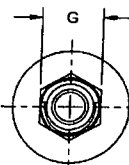
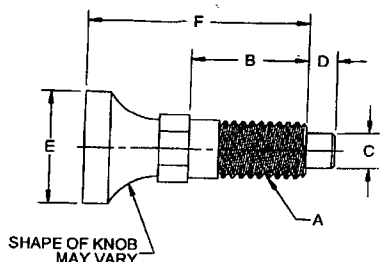
Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :							



SPECIFICATION CONTROL DRAWING

DAS
22 16.01.08
8-88

REF DIM.



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 146016

MLJ
151217

D3801-X HAND RETRACTABLE SPRING PLUNGER

DART P/N	SUPPLIER	SUPPLIER P/N	'A' THREAD SIZE	'B' THREAD LENGTH	'C' NOSE DIAMETER	'D' NOSE LENGTH	'E' HEAD DIAMETER	'F' LENGTH	'G' WIDTH ACCROSS FLATS	MATERIAL (BODY/ NOSE)	MATERIAL (KNOB)	TYPE	END FORCE (lbs)	WEIGHT (lbs)
D3801-1	REID SUPPLY COMPANY	KBP-504	3/8-24 UNF	0.67	0.197	0.20	0.83	1.71	0.50	303 SS	BLACK DELRIN	NON-LOCKING	2.7	0.01
D3801-3	REID SUPPLY COMPANY	PRT-22 OR PRT-22N	1/2-13 UNC	1.00	0.313	0.25	1.00	1.80	0.52	303 SS	WHITE DELRIN	NON-LOCKING	1.75	0.02

- NOTES:
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A

B	SUPPLIER P/N CHANGED: BODY/NOSE MAT'L WAS STEEL NOW STAINLESS STEEL.	MB	12.02.24
A	NEW ISSUE	MB	08.06.19
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. B
CHECKED		D3801	SHEET 1 OF 1
MFG. APPR.		TITLE	SCALE
APPROVED		HAND RETRACTABLE SPRING PLUNGER	NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.02.24		

RELEASED
2012-03-02



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO30763**

Purchase Order Date 12/17/2015

PO Print Date 12/17/2015

Page Number 1 of 2

Order From :

VU-RE1001

ESSENTRA COMPONENTS
62919 COLLECTION CENTRE DRIVE
CHICAGO, IL 60693-0629
US

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 800 253 0421

Ship To Contact

Ship To Phone

Ship Via: FedEx Intl Economy

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

FCA -- (Free Carrier)

E-MAILED

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable CD Promise Date	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	KBP-504 AS PER DWG D3801 REV. B B140016	Hand Retractable Spring Plunger	12/22/2015 Yes 12/22/2015	6.00 Each	\$24.46	\$146.76
Line Total:						\$146.76
2	BLRS-002	Quick Release Pin (3/16" x 1.5")	12/22/2015 Yes 12/22/2015	12.00 Each	\$29.14	\$349.68
Line Total:						\$349.68
3	CBL-460	Loop Sleeve	12/22/2015 Yes 12/22/2015	120.00 Each	\$0.21	\$25.20

Note:

12/17/2015

**ESSENTRA**

COMPONENTS

7240 Global Drive
Louisville, KY 40258
Phone: 800-847-0486
Fax: 814-898-1638
www.essentracomponents.com

DELIVERY NOTE#:

**P87103101957056**

CUSTOMER PO#

**PO30763**

Bill To: DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
CANADA

Ship To: DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
CANADA

**Load Number: 179190**

CUSTOMER NO		ORDER #	SHIPPED VIA	SHIP DATE	
45215650		1957056	FXIE FedEx Int'l Economy	12/17/15	
ORD LN	Item Description	Original Quantity	Quantity Shipped	Backorder Quantity	UM
1 ✓	KBP-504 3/8-24 NON-LOCKING SS PULL INDEXING PLUNGER Country Of Origin: DE	6.000	6.000		EA
2 ✓	BLRS-002A 3/16 X 1-1/2 SS BL PIN R - HANDLE Country Of Origin: US	12.000	12.000		EA
3 ✓	CBL-460 Z.P.COPPER LOOP SLEEVE FOR 1/16" CABLE Country Of Origin: US	120.000	120.000		EA

This is to certify that the above material shipped against your purchase order is in conformance with all known requirements, specifications and drawings in effect at the time of manufacture. All applicable physical, functional, dimensional and material test reports are on file at our facility, and may be inspected by your representative upon request.

Jeff Gillespie
Quality Manager

1. Vendor(Name and Address)

7240 Global Drive
Louisville, KY 40258

Commercial Invoice

2. Date of direct shipment to Canada

December 17, 2015

3. Consignee (Name and address) DART AEROSPACE 1270 ABERDEEN ST HAWKESBURY, ON K6A 1K7 CANADA		4. Purchasers name and address (If other than consignee) DART AEROSPACE LTD 1270 ABERDEEN ST HAWKESBURY, ON K6A 1K7 CA		
5. Other references (Include Purchase order's number) LOAD: 179190		6. Country of origin GERMANY		
7. Country of transshipment CANADA		8. Transportation: Give Mode and Place of Direct Shipment to Canada FXIE		
9. Currency of Settlement US Dollars		10. Item Description PLASTIC PROTECTIVE CAPS & PLUGS TARIFF ITEM# 3923.50.0000-7		
Pkgs.	Item Description	Quantity Shipped	Unit Price	Total
6 CTNS	KBP-504	6.000PCS	25.84	155.04
Shipping Clerk:		Part Weight .24	Tare Weight .26	Invoice Total 155.04

SP15-12-21